

Work Order ID 53468

November 6, 2009 8:38:11 AM



Page 1

Item ID: D3536-23

Revision ID: A

Item Name: Gasket

Start Date: 05/11/2009 Start Qty: 8.00

Required Date: 13/11/2009 Req'd Qty: 8.00

Reference:

Approvals: Process Plan: 12/ Date: 09-11-5 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3536	Rev A								

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3536 ☐ Dwg Rev: A ☐ Prog Rev: A ☐ 2-
Deburr if necessary

B 9-11-16

(12)

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

B 9-11-16

120

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

27 8 09/11/16

(12)

Work Order ID 53468

November 6, 2009 8:38:11 AM



Page 2

Item ID: D3536-23

Revision ID: A

Item Name: Gasket

Start Date: 05/11/2009 Start Qty: 8.00

Required Date: 13/11/2009 Req'd Qty: 8.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130



Packaging

Packaging

Identify as per dwg & Stock Location: _____

0.00

Memo

0.00

9/11/09 (12x) SP

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

09/11/17

MF
09-11-17

Picklist Print

November 6, 2009 8:38:16 AM

Page 1

Work Order ID: 53468



Parent Item: D3536-23RevA



Parent Item Name: Gasket

Start Date: 05/11/2009

Required Date: 13/11/2009

Comments:

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MNEO60S.063 		Purchased	No			100	sf	1,020.995	11.2547	17.		
NEOPRENE SHEET 0.063											B 9-11-16	

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	1020.9955	
112508	61.6034	
112662	320.2821	
112866	239.11	
113058	400	

112886

12

DART AEROSPACE LTD		Work Order:	53468
Description: Gasket		Part Number:	D3536-23
Inspection Dwg: D3536	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
52.85	+/-0.030	52.85	X			
48.20	+/-0.030	48.20	X			
44.70	+/-0.030	44.70	X			
39.31	+/-0.030	39.31	X			
33.92	+/-0.030	33.92	X			
28.53	+/-0.030	28.53	X			
23.14	+/-0.030	23.14	X			
17.75	+/-0.030	17.75	X			
14.25	+/-0.030	14.25	X			
9.50	+/-0.030	9.50	X			
4.75	+/-0.030	4.75	X			
8.00	+/-0.030	8.00	X			
16.00	+/-0.030	16.00	X			
24.00	+/-0.030	24.00	X			
32.00	+/-0.030	32.00	X			
39.00	+/-0.030	39.00	X			
48.00	+/-0.030	48.00	X			
0.30	+/-0.030	.302	X			
0.30	+/-0.030	.303	0			
1.89	+/-0.030	1.89	0			
Ø0.19	+0.005/-0.001	.189	X			

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 9-11-16	Date: 09/11/16	Date:	N/A

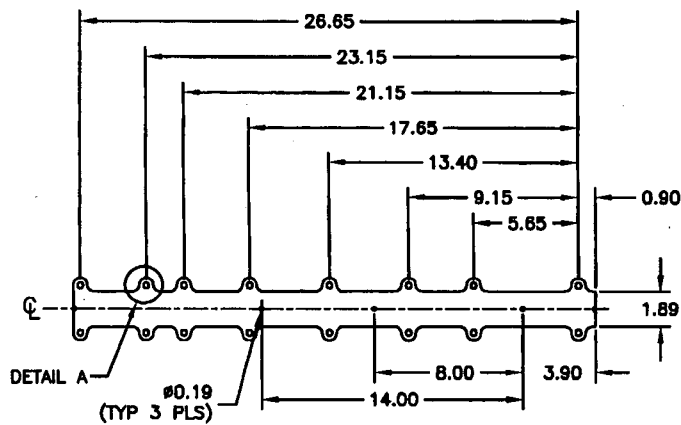
Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM	

DART

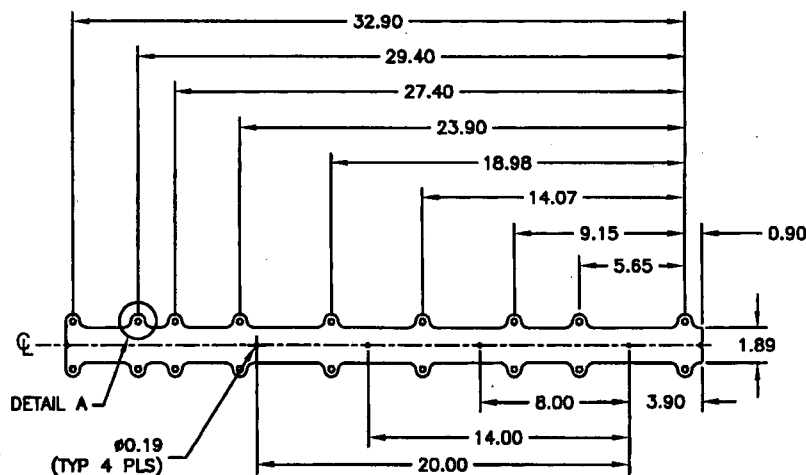
RELEASED
09-02-12

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.		
CB	CB	PORT HADLOCK, WA		
CHECKED AH	APPROVED AH	DRAWING NO.	D3536	REV. A
DATE 06.10.25		TITLE	GASKET	SHEET 1 OF 6
A	06.10.25	NEW ISSUE		SCALE 1:10

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 53468
09-11-5



D3536-11 GASKET



D3536-13 GASKET

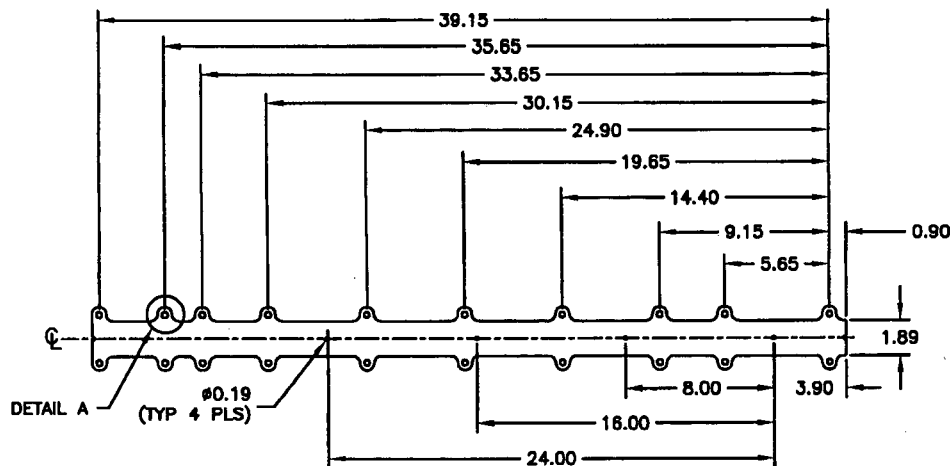
NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

DART

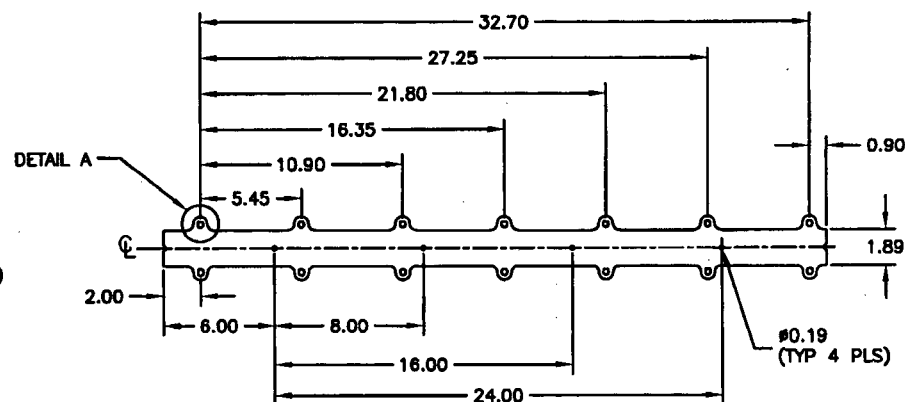
DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	DRAWING NO.	D3536	REV. A
		TITLE	GASKET	SHEET 2 OF 6
		SCALE	1:10	

RELEASED
0702.12



D3536-15 GASKET

w/o 534/8



D3536-21 GASKET

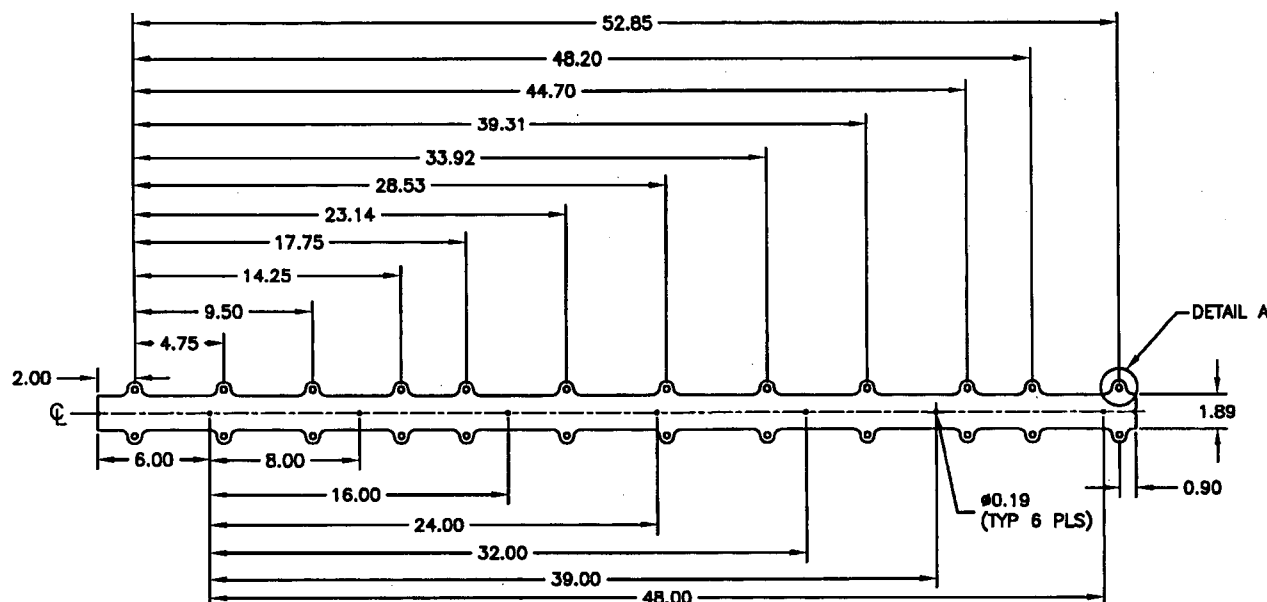
NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

DART

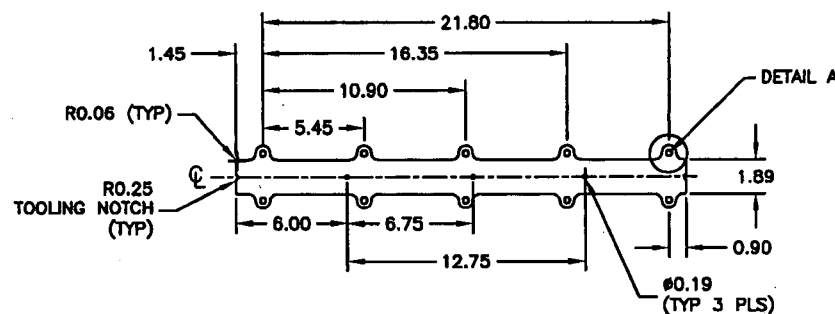
DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	DRAWING NO.	D3536	REV. A
		TITLE	GASKET	SHEET 3 OF 6
		SCALE	1:10	

RELEASED
07.02.12



D3536-23 GASKET

W/O 53468



D3536-25 GASKET

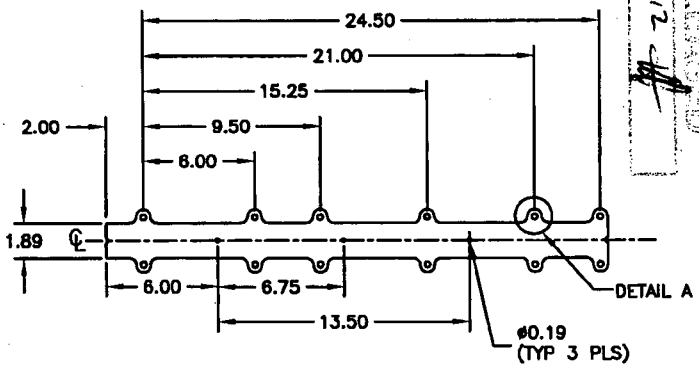
NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

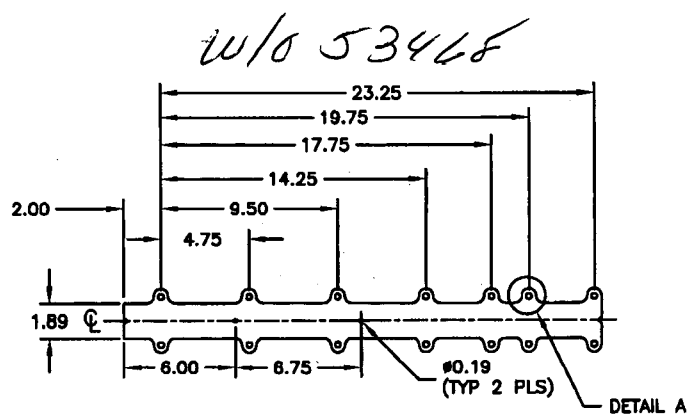
DART

DESIGN	C.B.	DRAWN BY	C.B.	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	DRAWING NO.	D3536	REV. A
		TITLE	GASKET	SHEET 4 OF 6
		SCALE	1:10	

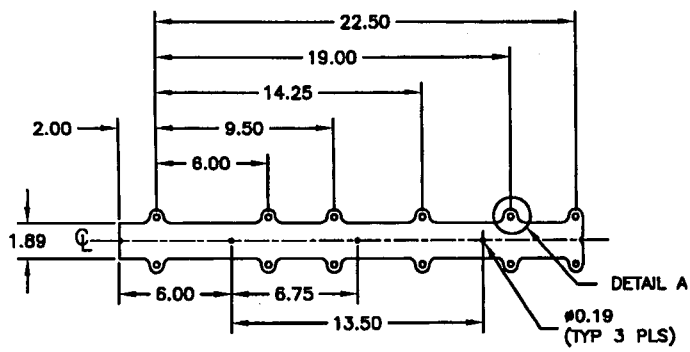
07.02.12



D3536-33 GASKET



D3536-35 GASKET



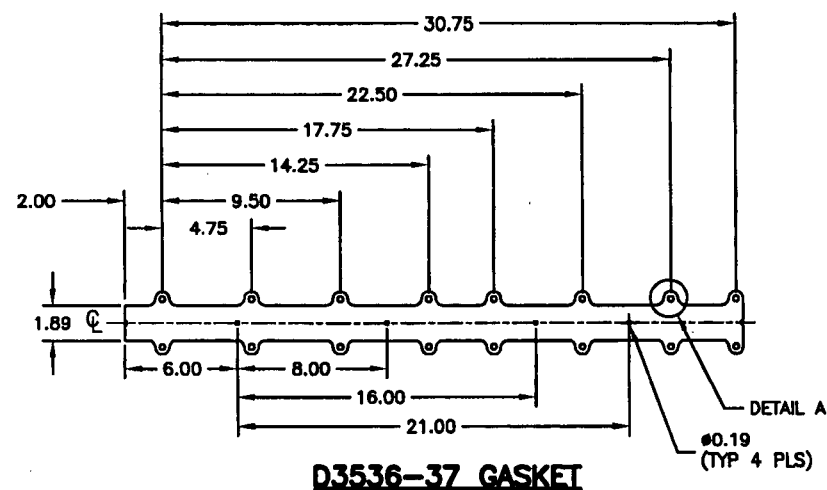
D3536-31 GASKET

- NOTES**
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 80 DUROMETER (REF DART SPEC. M-NE060-S.063)
 - 2) FINISH: NONE
 - 3) PART IS SYMMETRICAL ABOUT ϕ
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
 - 7) SEE PAGE 6 FOR DETAILS AND SECTION

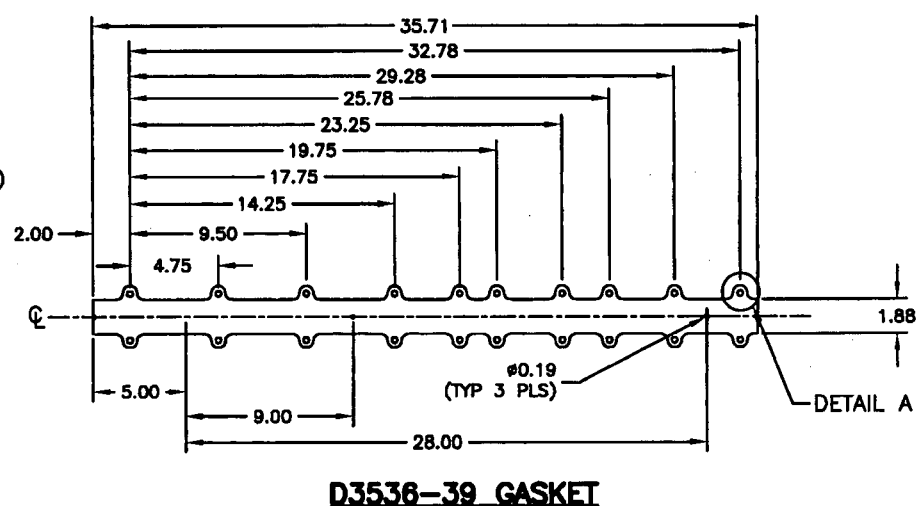
DART

DESIGN CB	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED PH	DRAWING NO. D3536	REV. A
DATE 06.10.25	TITLE GASKET	SHEET 5 OF 6	SCALE 1:10

07.02.12 *CH*



w/053468

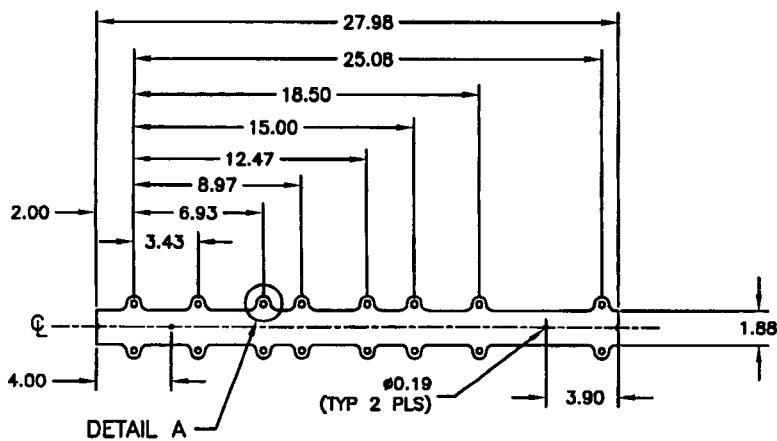


- NOTES**
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
 - 2) FINISH: NONE
 - 3) PART IS SYMMETRICAL ABOUT C
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
 - 7) SEE PAGE 6 FOR DETAILS AND SECTION

DART

RELEASED
07 JUL 82

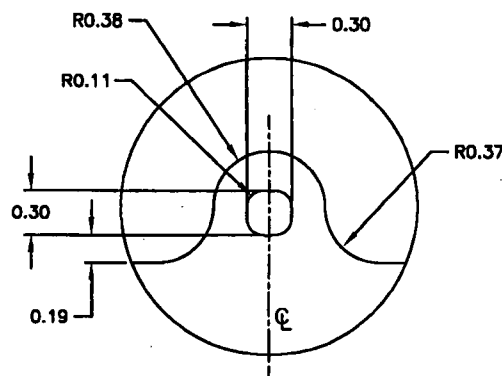
DESIGN CB	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED AM	APPROVED <i>[Signature]</i>	DRAWING NO. D3536	REV. A
DATE 06.10.25	TITLE GASKET	SHEET 6 OF 6	SCALE 1:10



D3536-41 GASKET

w/0 53468

DETAIL A



NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER